

Date: Monday, 3/19/2007 4:37:10 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OH-58 STEP ASSY RH *UNDER REVIEW**
 Job Number : 31294
 Estimate Number : 12439
 P.O. Number : *N/A*
 This Issue : 3/19/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : LARGE FAB ASSY
 Previous Run : 30794
 Part Number : D058677012
 Drawing Number : D2943 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : UNDER *Rev B* 07.03.20
 Material : *N/A*
 Due Date : 4/6/2007 Qty: 5 Um: Each
 Written By :
 Checked & Approved By : *07.03.20*
 Comment : Est Rev B 01.04.11 Combined with D2943-041 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD058-677-012 CHG001

CL KS 07.03.20

2.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Extrusion D2622-120C

Batch: *B30199*

FF 07-05-01 5

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

D2734 206 Step Endplate

Batch: *B27281*

FF 07-05-01 5

4.0 D2725 206 Step Lug



Comment: Qty: *(2)* 1.0000 Each(s)/Unit Total *(10)* 5.0000 Each(s)

2 Lugs per step D2725 206 Step Lug

Batch: *B22972 = 9 B29340 = 1*

FF 07-05-01 5

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT 8483

A/R AL ROD Batch: *M102956 M103317*

FF 07-05-01 5

FF 07-05-02 5

FF 07-05-02 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Grind end cap welds flush as per dwg D2943

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

LE 07.05.02 (5)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

LE 07/05/03 (5)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 07/05/07

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 07-05-08 5

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482

A/R AL ROD Batch: *M102756*

LE 07.05.09 5

2-Grind end cap welds flush as per dwg D2943

FF 07-05-09 5

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

LE 07/05/09 (5)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

LE 07/05/09 (5)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

AL 07-05-16 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: OH-58 STEP ASSY RH *UNDER REVIEW**

Job Number: 31294

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

POWDER COATING

POWDER COATING



M103706



(5X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L

07/05/16

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2943 and QSI 005 4.4

Batch: M103707

SA/MH

07/05/16 (5)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

20705-17(5)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20705-17(5)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

19.0

D27311

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Mounting Lug

Batch: 109941

(8) X 2 X 109112

20.0

D27313

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Mounting Lug

327710 ✓

21.0

D27315

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Mounting Lug

Batch: 1023330

(6) X (4) X 7/5/17 SP
B27700

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 31294

Part Number: D058677012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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22.0	D27317	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Mounting Lug

Batch: M29339 ✓

23.0	AN411A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Batch: M162280 ✓

24.0	AN412A	Bolt
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Batch: M103947 ✓

25.0	AN960JD416	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Washer

Batch: M102929 ✓

26.0	MS21042L4	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nut

Batch: M102552 ✓

27.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

28.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Do58-677-012

Location: B

PPP Rev: 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 31294

Part Number: D058677012

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

19 07/05/17

Job Completion



U 07/05/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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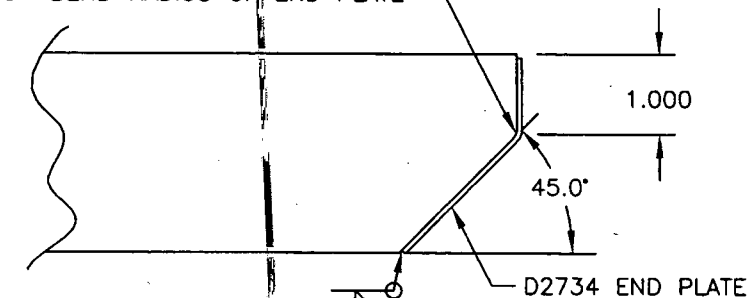
DART

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

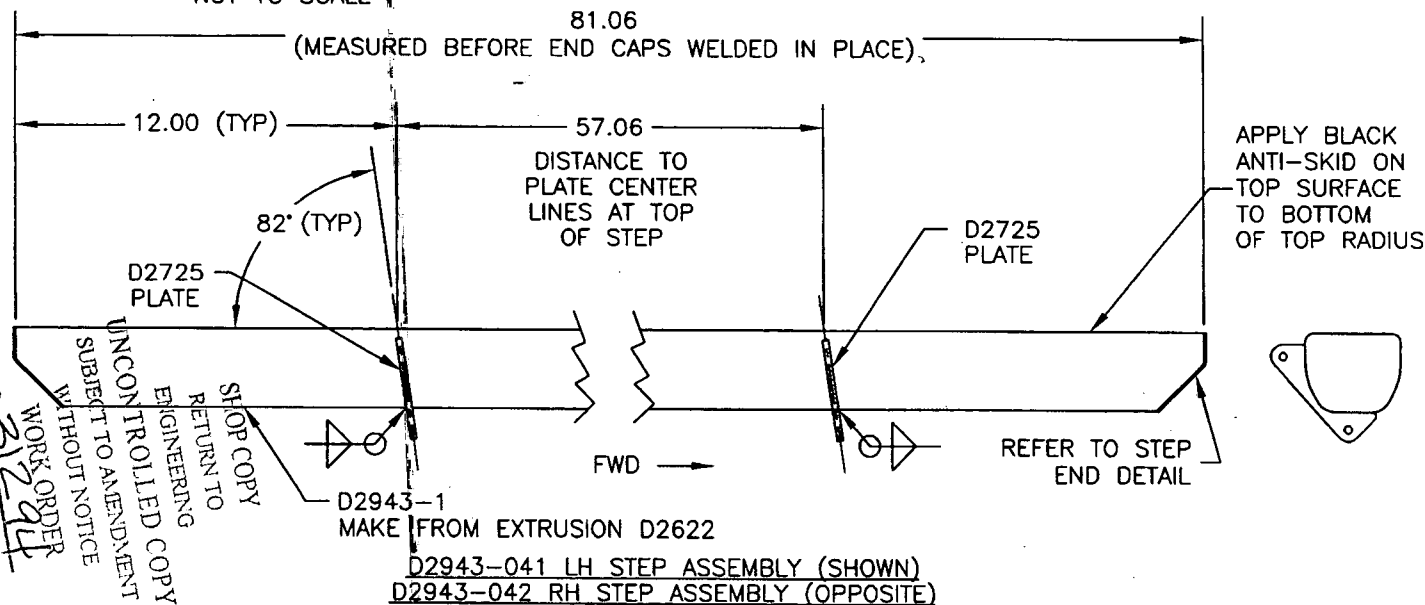
DESIGN	RF	DRAWN BY	DATE	CHECKED	APPROVED	DRAWING NO.	TITLE	SCALE
		<i>gjt</i>	05.11.14	<i>[Signature]</i>	<i>[Signature]</i>	D2943	OH-58 STEP ASSEMBLY	NTS
A			99.11.19				NEW ISSUE	
B			05.11.14				UPDATE FINISHING NOTE	

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE



D2943-041 LH STEP ASSEMBLY (SHOWN)
D2943-042 RH STEP ASSEMBLY (OPPOSITE)

D2943-041/-042 OH-58 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
X	-041	D2943-041	LH STEP ASSEMBLY
	X	D2943-042	RH STEP ASSEMBLY
1	1	D2622-082*	EXTRUSION
2	2	D2725	PLATE
2	2	D2734	END PLATE

*out per drawing

D2943-041/-042 OH-58 STEP ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.28-110

UNDER REVIEW
Ref 02.03.00
06.03.09
RE-DESIGN
SYNOPSIS TO 0206-637